

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020037**Date Inspected:** 14-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12AE, Deck Panel Diaphragm.

FCAW welding of weld joint DP3007-001-248, 249; located on assembly, Bay 14, 12AE. Welder is identified as 214945; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2233-TC-U4B-F.

Assembly, Bay 14, 12AW, Bottom Panel to Longitudinal Diaphragm.

FCAW welding of weld joint SEG3004V-049, 045; located on assembly, Bay 14, 12AW. Welder is identified as 045175; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Assembly, Bay 14, 12AW, Bottom Panel to Longitudinal Diaphragm.

FCAW welding of weld joint SEG3004V-051, 056; located on assembly, Bay 14, 12AW. Welder is identified as 201215; ZPMC Quality Control Inspector (QC) is identified as Geng Wei. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2232-TC-U4B-F.

Assembly, Bay 14, 12AE

# WELDING INSPECTION REPORT

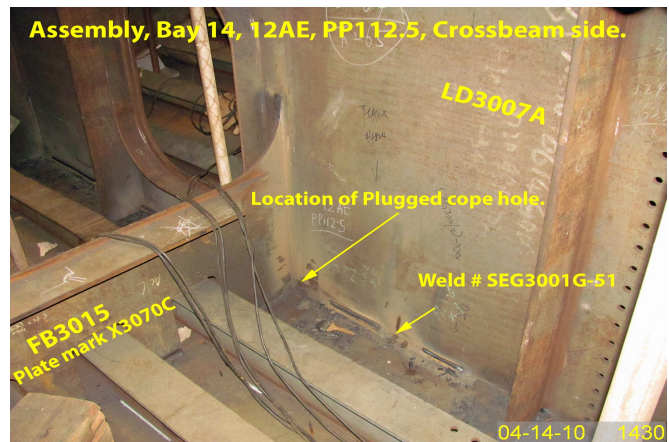
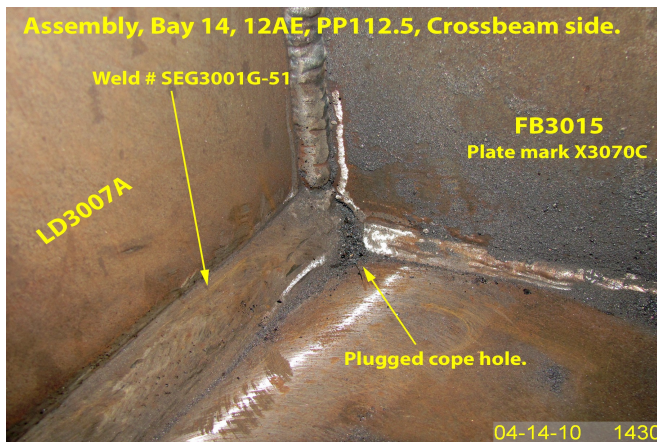
( Continued Page 2 of 3 )

During Quality Assurance (QA) random in-process observations of the assembly of Orthotropic Box Girder (OBG) segment 12AE, this QA Inspector discovered the following issue:

- The weld access hole has been plugged due to the termination of an oversized fillet weld.
- The approved shop drawings detailed the weld access hole as 25mm radius.
- The location of the weld access hole is at the end of Floor Beam FB3015, joining Panel Point (PP) 112.5.
- The fillet weld is identified as: SEG3001G-51
- The weld was detailed on the approved drawings as: 6mm
- The oversized fillet weld (SEG3001G-51) was measured between 20mm to 23mm.
- OBG Segment 12AE is located in OBG Bay 14.

The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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| <b>Inspected By:</b> | Juvekar,Amit | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Miller,Mark | QA Reviewer |
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